

What is claimed is:

1. A chip removal method that removes residue such as chips that have remained in and adhered to an interior of a bag-shaped machined hole in a work piece, wherein  
5 after air is jetted out and blown against a bottom portion of the machined hole by using an air blow nozzle to change a flow of air that is circulating inside a nozzle into a spiral flow that moves in a direction towards the bottom portion of the machined hole, this spiral flow then blows upwards like a tornado from a vicinity of the bottom portion of the machined hole in a direction towards an aperture portion of the machined hole so  
10 that the residue inside the machined hole is uplifted by the spiral flow and removed.
2. A chip removal air blow nozzle that removes residue such as chips that have remained in and adhered to an interior of a bag-shaped machined hole in a work piece comprising:  
15 a nozzle distal end portion that is inserted into the machined hole; and  
a spiral flow creating portion that is provided in the nozzle distal end portion and changes a flow of air that is circulating inside the nozzle into a spiral flow.
3. The chip removal air blow nozzle according to claim 2, wherein the spiral flow  
20 creating section has a plurality of guide pieces that are formed at the distal end portion of the nozzle and are twisted into a screw shape.
4. The chip removal air blow nozzle according to claim 2, wherein, when the  
machined hole is a female threaded hole, the spiral flow turns in a direction in which the  
25 thread is loosened.